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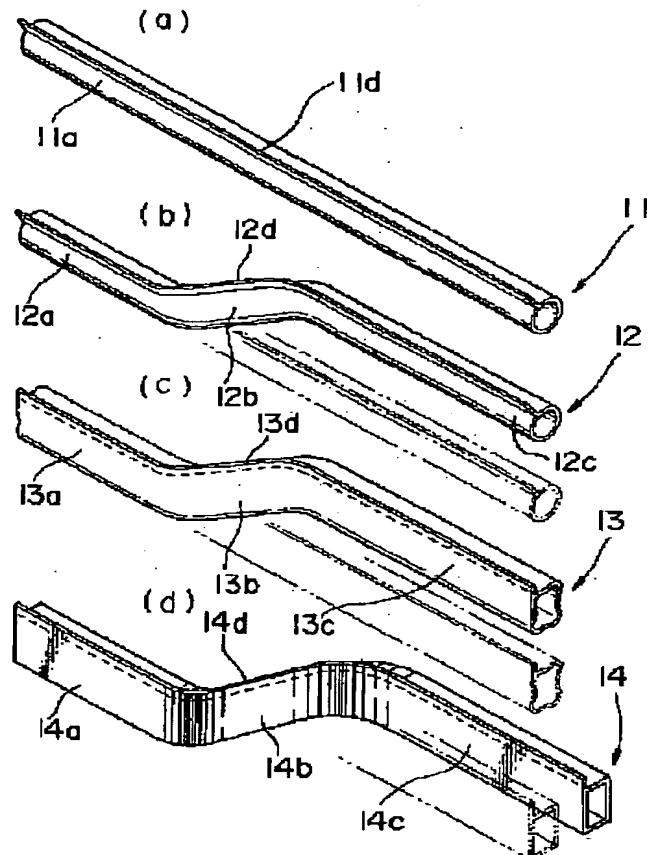
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TITLE : MANUFACTURE OF CYLINDRICAL  
MEMBER FOR VEHICLE STRUCTURE



ABSTRACT : PURPOSE: To form a vehicle structural member composed of an aluminum material having rectangular cross section curved in three dimensions without developing fold and crack on the wall surface.

CONSTITUTION: After extrusion-forming a cylindrical member 11 having almost circular shaped cross section integrally erecting a flange, a cylindrical member 12 is obtd. by curving in a vertical plane by bending. Successively, the wall surface of this cylindrical member 12 is pressed in the vertical direction and in the horizontal direction by using metallic mold and the cross sectional shape is deformed from the circular shape to almost the rectangular cross section and also, the flange is bent in the prescribed direction to obtain a cylindrical member 13. Further, a bulging formation for loading the pressure in the inner part of the cylindrical member 13 is executed in the condition of holding the cylindrical member 13 in the inner part of the metallic mold and the cylindrical member is brought into close contact with the metallic mold to deform this cross sectional shape into the rectangular shape.

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